

Work Order ID 154067

Thursday, December 01, 2016 10:37:04 AM

154067

Page 1

Item ID: D2654-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Web

Start Date: 11/30/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 12/2/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: **DAS**Date: **DEC 01 2016**

Tooling:

Date:

Run Start ***NR1***QC: **21**Date: **9-89**

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2654

F

100

0.00

100

Skidtubes

Skidtubes

Memo

0.18

Skidtubes

1-Cut D2600-5 to length as per Dwg D2654
2-Drill pilot holes in web using drill jig DT 8018-3 as per Dwg D2654
3-Using the uni-bit, open holes to finish size as per Dwg D2654
4-Deburr holes and ends

mgly
DP
17/02/28

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.01

Quality Control

2 0 1703-14

DAS
18
9-89

120

Chemical Conversion Coat per QSI005 4.1

0.00

120

HandFinish

Memo

0.13

Hand Finishing

(x2) 0 201203/15
BEB

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

Work Order ID 154067

Thursday, December 01, 2016 10:37:04 AM

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Page 2

Item ID: D2654-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Web

Start Date: 11/30/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 12/2/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC7-Inspect Chemical Conversion Coat

0.00

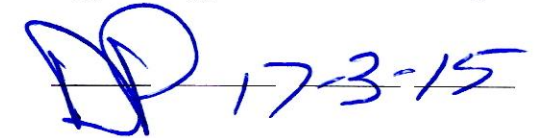
130

QC

Memo

0.00

Quality Control



140

Identify as per dwg & Stock Location: _____

0.00

140

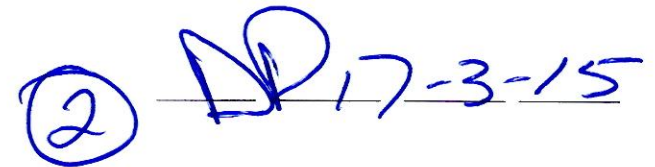
Packaging

Memo

0.00

Packaging

LOCATION: LG002



150

QC21- Final Inspection - Work Order Release

0.00

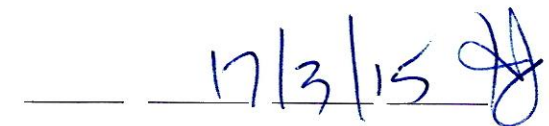
150

QC

Memo

0.03

Quality Control



MAR 15 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

Picklist Print

Thursday, December 01, 2016 10:37:04 AM

Page 1

Work Order ID: 154067

154067

Parent Item: D2654-3

D2654-3

Parent Item Name: Web

Start Date: 11/30/2016

Required Date: 12/2/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:D 99.02.04 Fixed typo, Changed procedure DM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2600-5-108

Manufactured

No

100

Each

240.0000

1

2

D2600-5-108

Extrusion 'I Beam' thin

WAG
17/2/27

Location

Loc Qty

Loc Code

HALL

240

145248

240

2
145248

DQA: _____ Date: _____

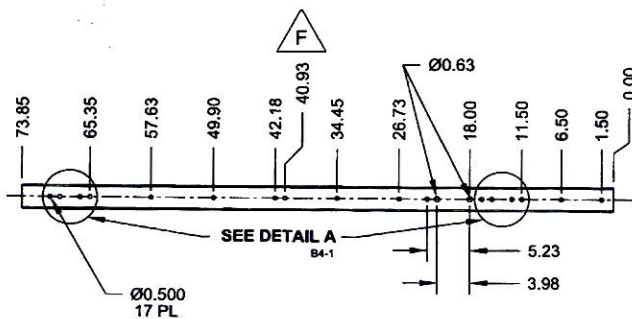
WORK ORDER NON-CONFORMANCE / UPDATE



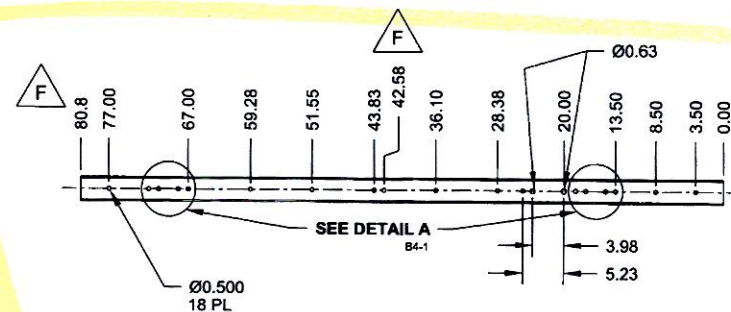
QA Closed: _____ Date: _____

Work Order update only ☐

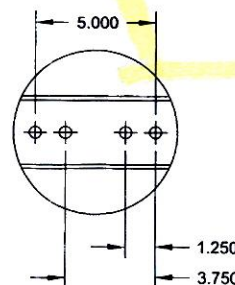
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Misidentified ☐	Past Due ☐																																																																



D2654-1 WEB



D2654-3 WEB



DETAIL A

C2-1
C3-1
C6-1
C8-1
D3-2
D6-2
B3-2
B6-2

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 154067 MLJ
1612-01

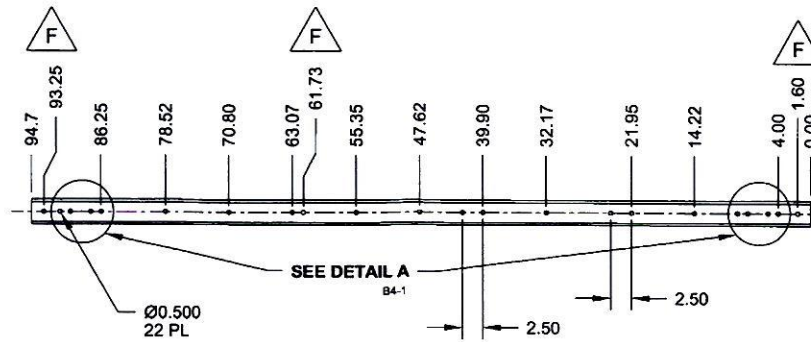
RELEASED
2011-09-12

NOTES:

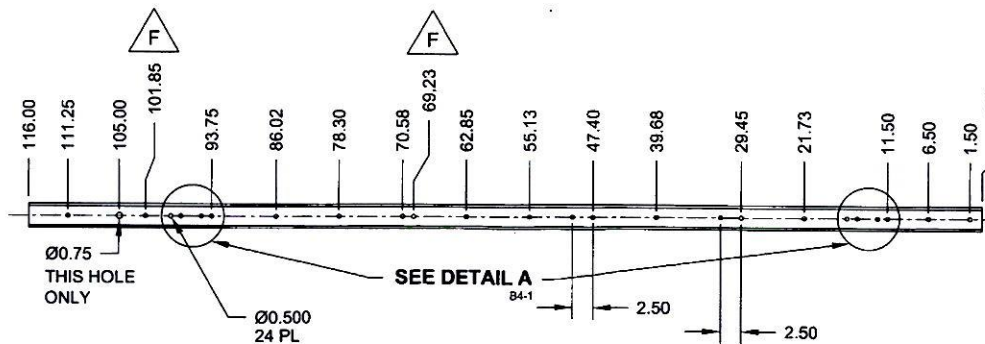
- 1) MAKE D2654-1/-3 FROM D2600-5-108 EXTRUSION, MAKE D2654-5/-7 FROM D2600-7-125 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH P/N "D2654-X" PER QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: D2654-1 = 2.2 lbs; D2654-3 = 2.4 lbs
D2654-5 = 4.8 lbs; D2654-7 = 5.8 lbs

REV.	DESCRIPTION	BY	DATE
F	ADDED ADDITIONAL HOLES ON -5/-7, 80.8 WAS 80.5, INCORPORATED DEO D2654-E-2	SC	11.05.05
E	CHANGE LENGTHS, REFORMAT	CP	04.05.26
D	GHW HOLES CHANGED TO Ø0.63	CP	98.01.15
C	CHANGED HOLE PATTERN	CP	97.10.29
B	ALTER HOLE PATTERN, 0.500 WAS 0.438	CP	97.06.26
A	NEW ISSUE	CP	97.03.25
DESIGN	CP	DART AEROSPACE USA, INC	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	9	DRAWING NO.	REV. F
MFG. APPR.	12	D2654	SHEET 1 OF 2
DE APPR.	12	TITLE	SCALE
DATE	11.05.05	WEB	NTS

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D2654-5 WEB



D2654-7 WEB

RELEASED
2011-09-12

DESIGN	CP	DART AEROSPACE USA, INC	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D2654	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEB	NTS
DATE	11.05.05	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC	